

SPCIT

Date: Thursday, 10/19/2006 2:50:34 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 29078	
Estimate Number : 11856	
P.O. Number : N/A	Part Number : D23625
This Issue : 10/19/2006 S.O. No. : N/A	Drawing Number : D2362 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : N/A	Material : N/A
Written By : [Signature]	Due Date : 10/27/2006
Checked & Approved By : [Signature]	Qty: 12 Um: Each
Comment : Est: D 00:04.24 Removed P/O from powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	B 29079

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-5

Deburr

En 06/11/17

PTO x 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

En 06/11/17

x 12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06/11/17

5.0	POWDER COATING	POWDER COATING
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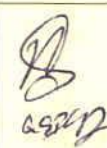
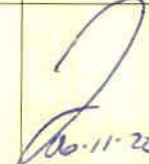
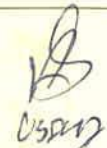
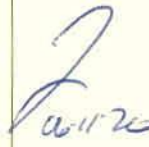
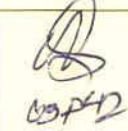

Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

Y/L 06/11/20 x 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/11/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/23	#20	one part scrap. holes for $\phi 25.7 \times 0.75$ slot Drill in wrong location.		Fix program D0362-5 Scrap / destroy and Repke	Er 06/11/23			
06/11/23	#20	one part scrap. moved out of packet when Driller operator error		scrap / destroy / Repke Remind operator to pay more Attention	Er 06/11/23			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29078

Part Number: D23625

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB 06/11/21 (12)

7.0

D23975

Rubber Cushions



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-5

Rubber

B8952

SB 06/11/21 (12)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-5 using contact cementas per Dwg D2362

SB 06/11/21 (12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/21 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51/72

SB 06/11/22 (12)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/23 (12)

Job Completion



U 06.11.23



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	<i>CP</i>		
CHECKED	APPROVED	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN. ADD 2397-5	

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
313 BEFORE MANUFACTURE

OK 01/01/07

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
29078

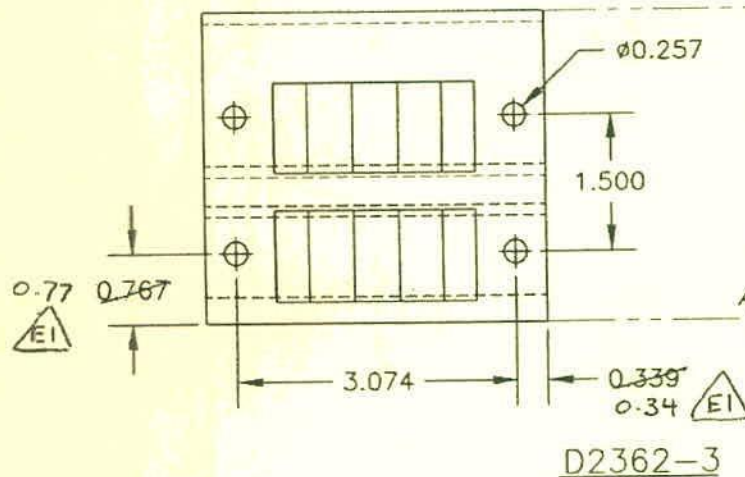
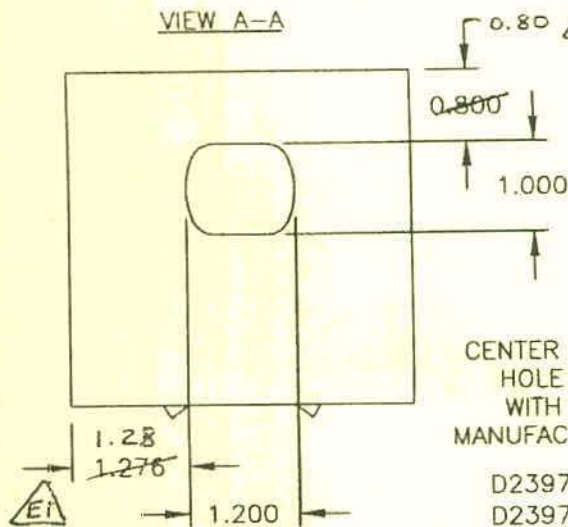
0.257 X 0.75 SLOT

REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	

RELEASED
98.12.14 KE
UNDER REVIEW

DESIGN OK, BUT CHECK BY
D23 BEFORC MANU FACTURE
OK 1/10/99

MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

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WITHOUT NOTICE
WORK ORDER
21018

0.257 X 0.75 SLOT

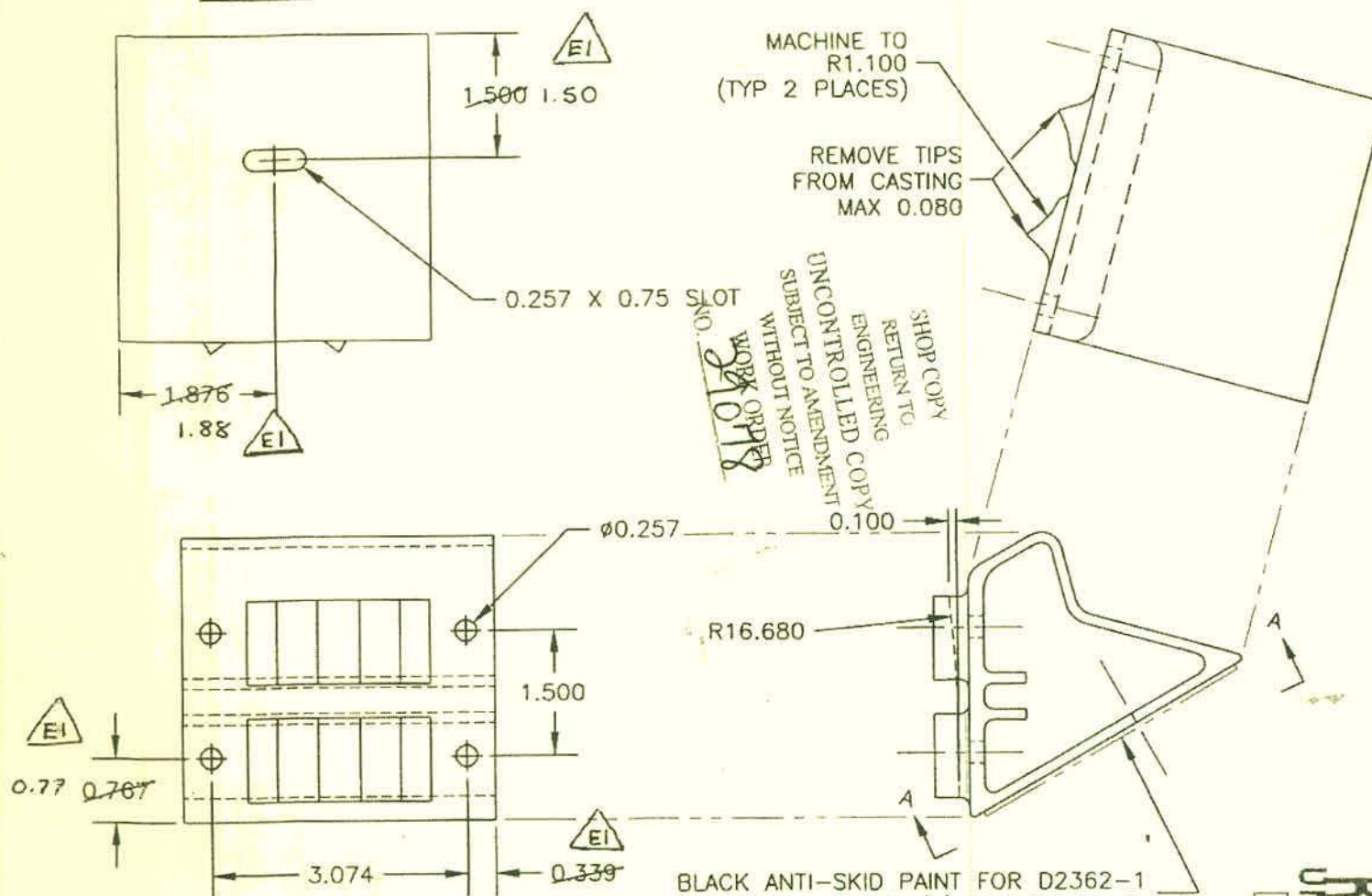
Ø0.257

R16.680

D2362-1 & D2362-5

BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW**RELEASED**

01/03/15 *CP*
DESIGN OK BUT CHECK WITH
JTS BEFORE MANUFACTURE

OK 98.12.04

D2362-7

REMOVE TIPS
FROM CASTING
MAX 0.080

3.750 (REF)

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004

Ø0.257

0.339 0.34

3.074

EI

0.767

1.500

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. *29078*
WORK ORDER

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

